

Date: Monday, 10/16/2006 2:02:59 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPRING CLIP ASSEMBLY
 Job Number : 29025
 Estimate Number : 10645
 P.O. Number : N/A Part Number : D2429041
 This Issue : 10/16/2006 S.O. No. : N/A Drawing Number : D2429 REV C1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : C1
 Previous Run : 27523 Material : N/A
 Due Date : 10/30/2006 Qty: 40 Um: 20 Each
 Written By :
 Checked & Approved By :
 Comment : Est. D 02-06-06 Added note at step 7 NG
 Est Rev:E Now on Waterjet 06-06-13 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.0071 sf(s)/Unit Total: 0.1428 sf(s)

304/316 .040 Sheet

(M304S040) m 101264 m 06 12 01

Batch: m 102159 m 06 10 18

(40)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2429

Dwg Rev: C1

Prog Rev: C1

m 06 10 18 m 06 12 01

(40)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m 06 12 01

(40)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Joe 10-18 (20)
 Counted. 11/06/12/01 (20)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend D2429-1 as per Dwg D2429

m 06 10 18 (20)

SB 06 12 05 (20)

SB 06 11 21 05

40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/12/05	5.1	Add QCS to step 5.1 Perm. chg.	E	06.12.05	(40)		AA 06/12/05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/12/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:02:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 29025

Part Number: D2429041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part number	Description	Batch
1	MS20470AD4-5	Rivet	M18491

SB 06/12/06

(20)

7.0

AN960JD6L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty	Part number	Description	Batch
2	AN960JD6L	Washer	M5519

NOTE: 2 D2429-1 required for 1 assy.

SB 06/12/06

20

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

SB 06/12/06

(20)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/12/06

(20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST45

SB 06/12/07

(20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 06/12/08

(20)

Job Completion



U 06/12/08

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

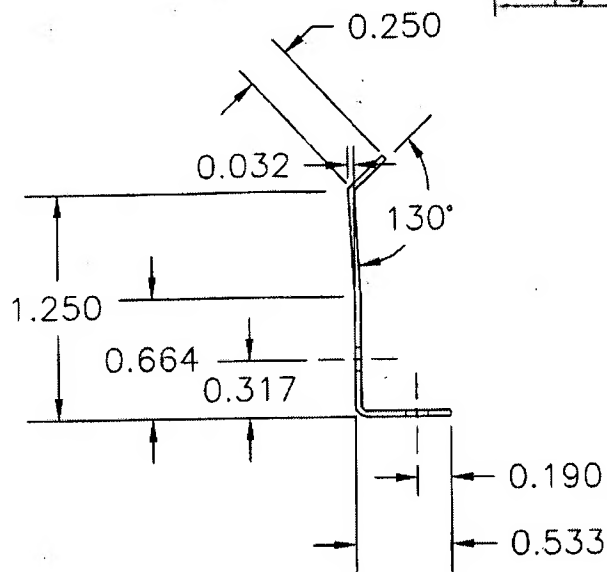
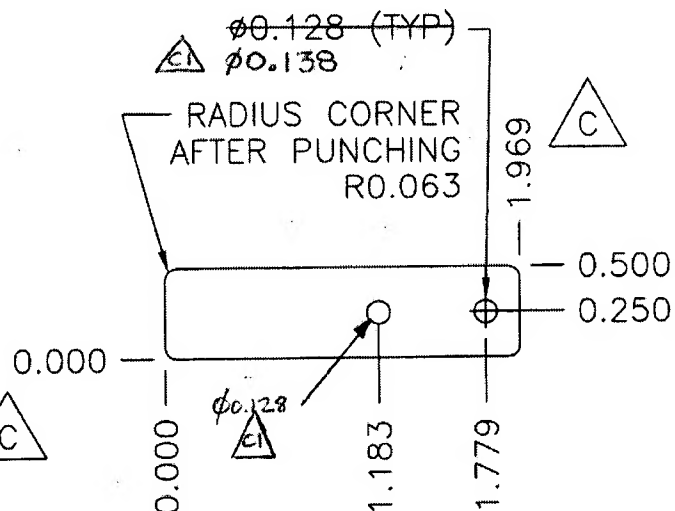
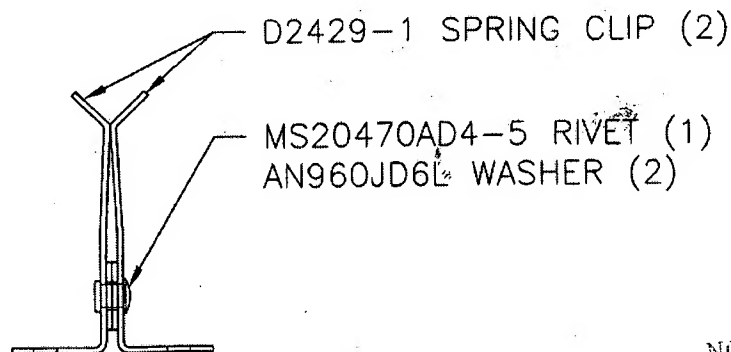
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26	TITLE SPRING CLIP		SCALE 1:1
A	95.07.21	NEW ISSUE	
B	97.10.09	ADDED ASSEMBLY	
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
C1	01.03.27	ø0.138 WAS ø0.128	

RELEASED
00.06.27 #D2429-1 SPRING CLIPD2429-1 FLAT PATTERND2429-041 SPRING CLIP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29025

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES

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DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x	First Article
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X	Prototype
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[illegible]

Measured by: <i>M. M.</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: <i>06-10-18</i>	Date: <i>06-10-18</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	